

Work Order ID 61216-1

Wednesday, August 11, 2010 10:23:06 AM



Page 1

Item ID: D3065-041

Accept



Setup Start



Revision ID:

Item Name: Step Leg Assembly Hi

Stop



Start Date: 8/12/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 9/2/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 10-8-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3065	Rev B

100	Small Fab	0.00							
	Small Fab	Memo							
Small Fab	Assemble as per Dwg D3065 and Identify as D3065-041								

JS 10/09/08 (29)

110	QC5- Inspect part completeness to step on W/O	0.00							
	QC	Memo							
Quality Control									

S 10/09/07

count
(29)

120	Identify as per dwg & Stock Location: <i>WA</i>	0.00							
	Packaging	Memo							
Packaging									

10-09-08

29 *φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/08
MF
10-9-08

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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 11, 2010 10:23:05 AM

Page 1

Work Order ID: 61216

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi



Start Date: 8/12/2010

Required Date: 9/2/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1 Step Spacer		Manufactured	No			100	Each	70.0000	1	40			
<div> <div>Location</div> <div>GA</div> <div>59860</div> <div>WA</div> <div>58210</div> </div> <div> <div>Loc Qty</div> <div>52</div> <div>52</div> <div>18</div> <div>18</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
D3065-3 Step Spacer		Manufactured	No			100	Each	71.0000	1	40			
<div> <div>Location</div> <div>GA</div> <div>59853</div> <div>WA</div> <div>48113</div> <div>60312</div> </div> <div> <div>Loc Qty</div> <div>14</div> <div>14</div> <div>57</div> <div>10</div> <div>47</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>													
D3065-5 Step Leg		Manufactured	No			100	Each	81.0000	2	80			
<div> <div>Location</div> <div>GA</div> <div>59851</div> <div>60311</div> </div> <div> <div>Loc Qty</div> <div>81</div> <div>1</div> <div>80</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

EP 8/09/06
B61416 (10x)

EP 8/09/06
B61415 (8x)

EP 8/09/06
B61202 (57x)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, August 11, 2010 10:23:05 AM

Page 2

Work Order ID: 61216



Parent Item: D3065-041



Parent Item Name: Step Leg Assembly Hi

Start Date: 8/12/2010

Required Date: 9/2/2010

Start Qty: 40.00

Required Qty: 40.00

D3065-7

Manufactured

No

100

Each

55.0000

1

40



Step Spacer



Handwritten: 8/5/09/00
36/2/01
(14x)

Location

Loc Qty

Loc Code

GA

55

59854

15

60313

40

MS20470AD4-4

Purchased

No

100

Each

1,945.000

30

1200

870



Rivet, Universal Head



Handwritten: 8/5/09/00
750
115

Location

Loc Qty

Loc Code

ST319

1940

112314

30

113368

92

115156

1818

ST321

5

114761

5

Wednesday, August 11, 2010 10:23:05 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

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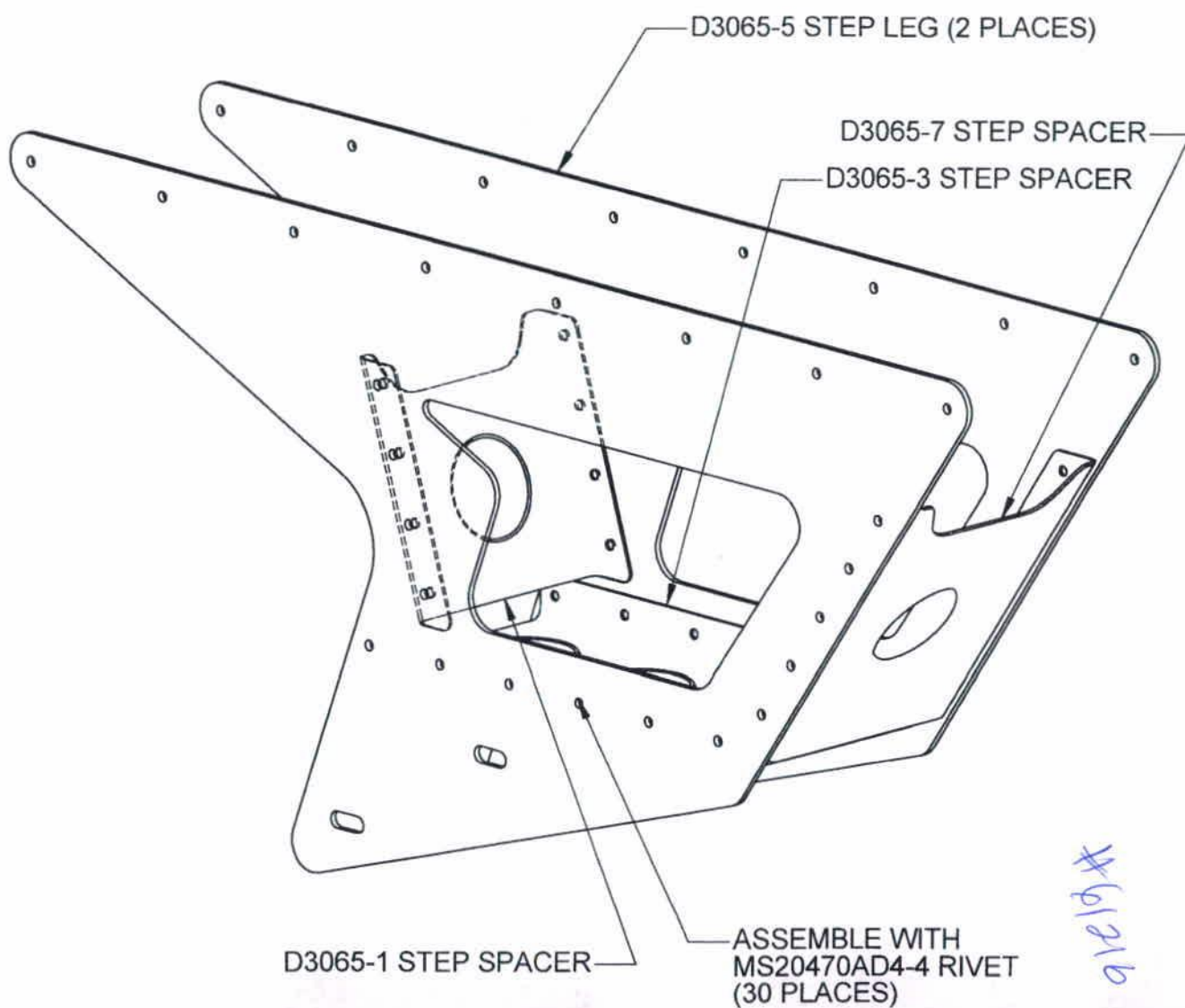
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

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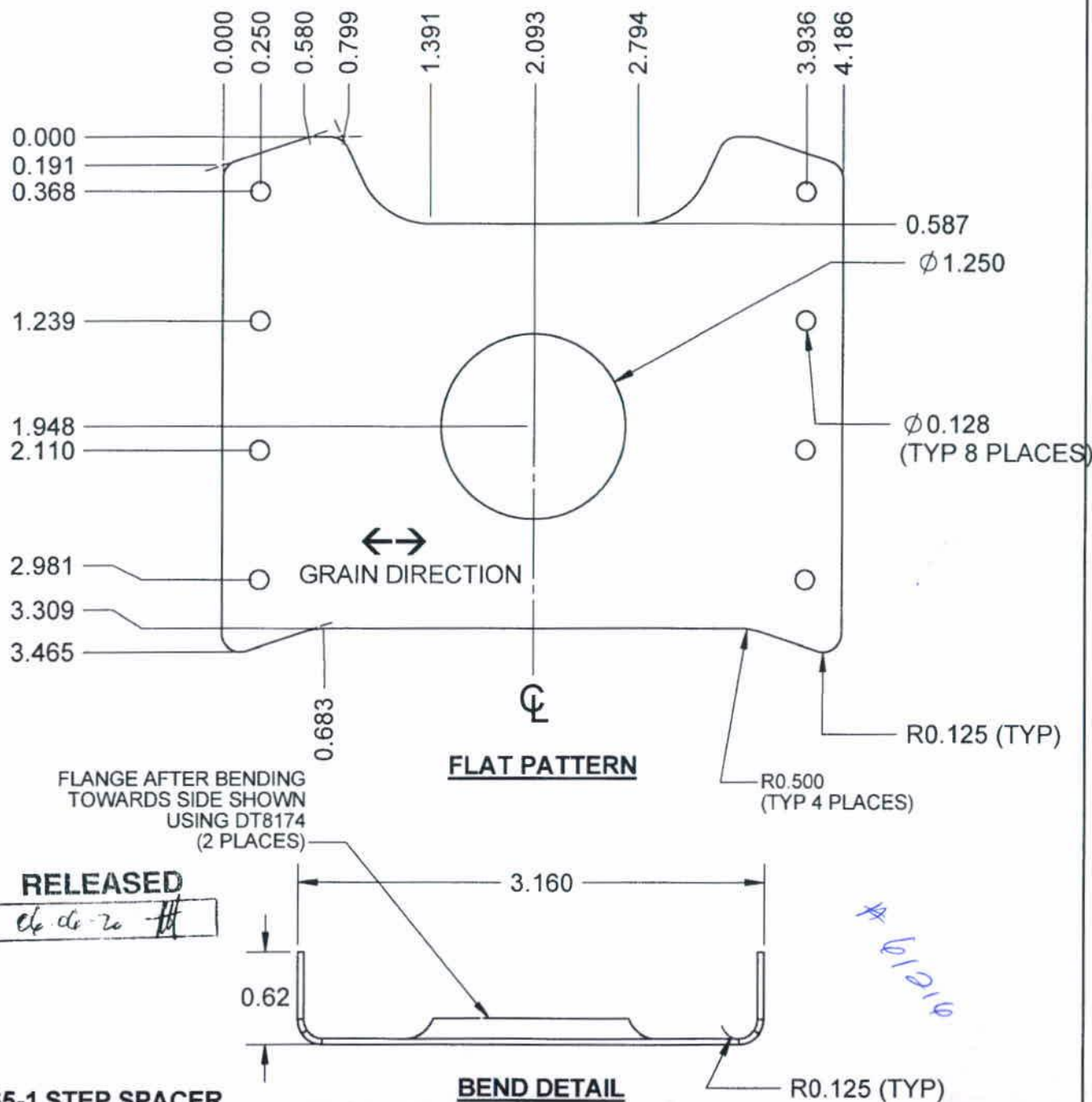
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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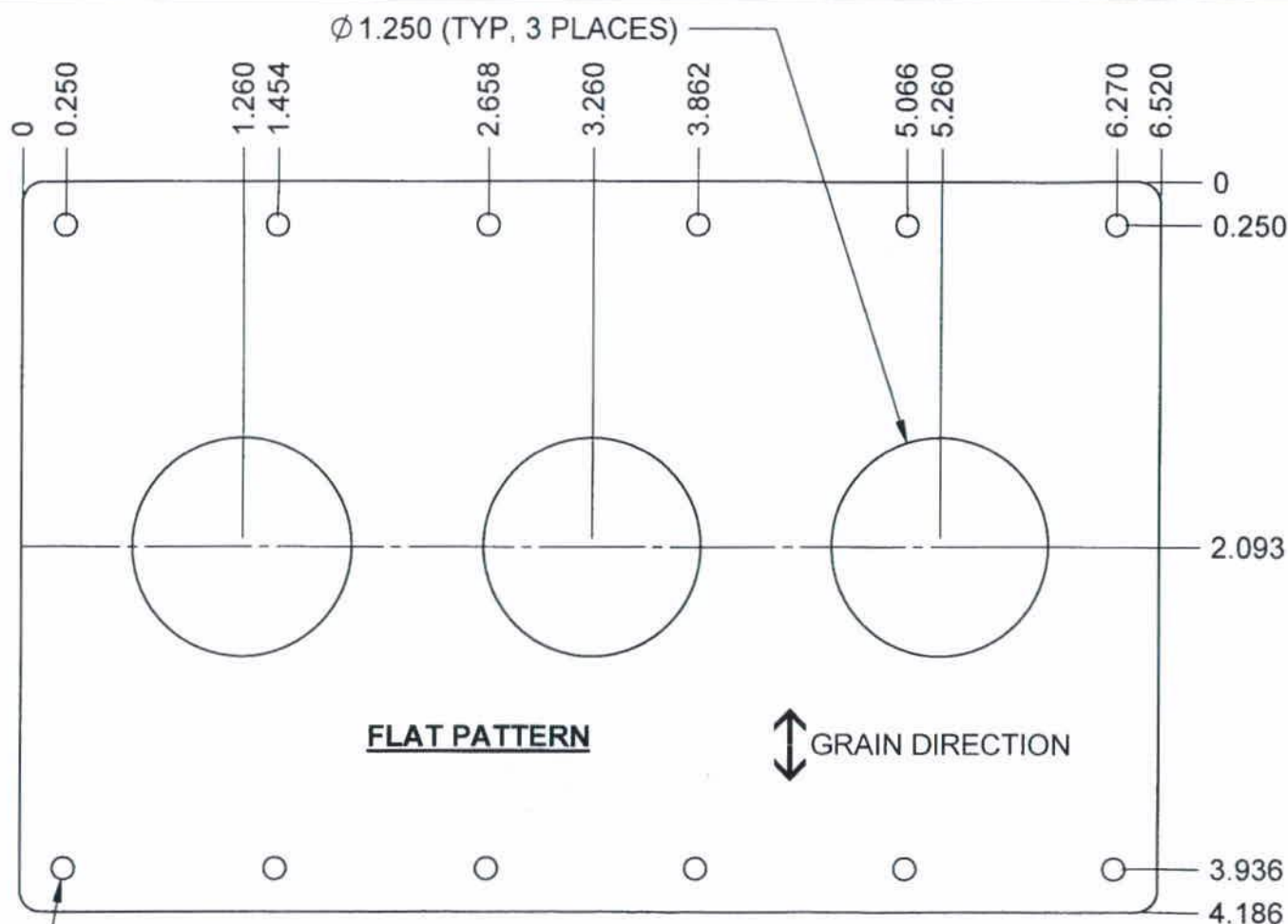
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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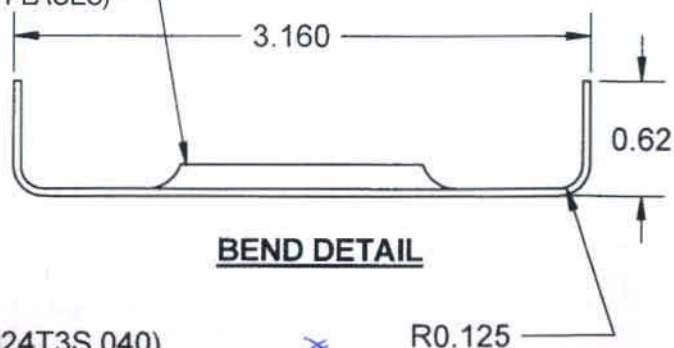


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø0.129 (TYP, 12 PLACES)

RELEASED

Ob de 20 - ~~11~~



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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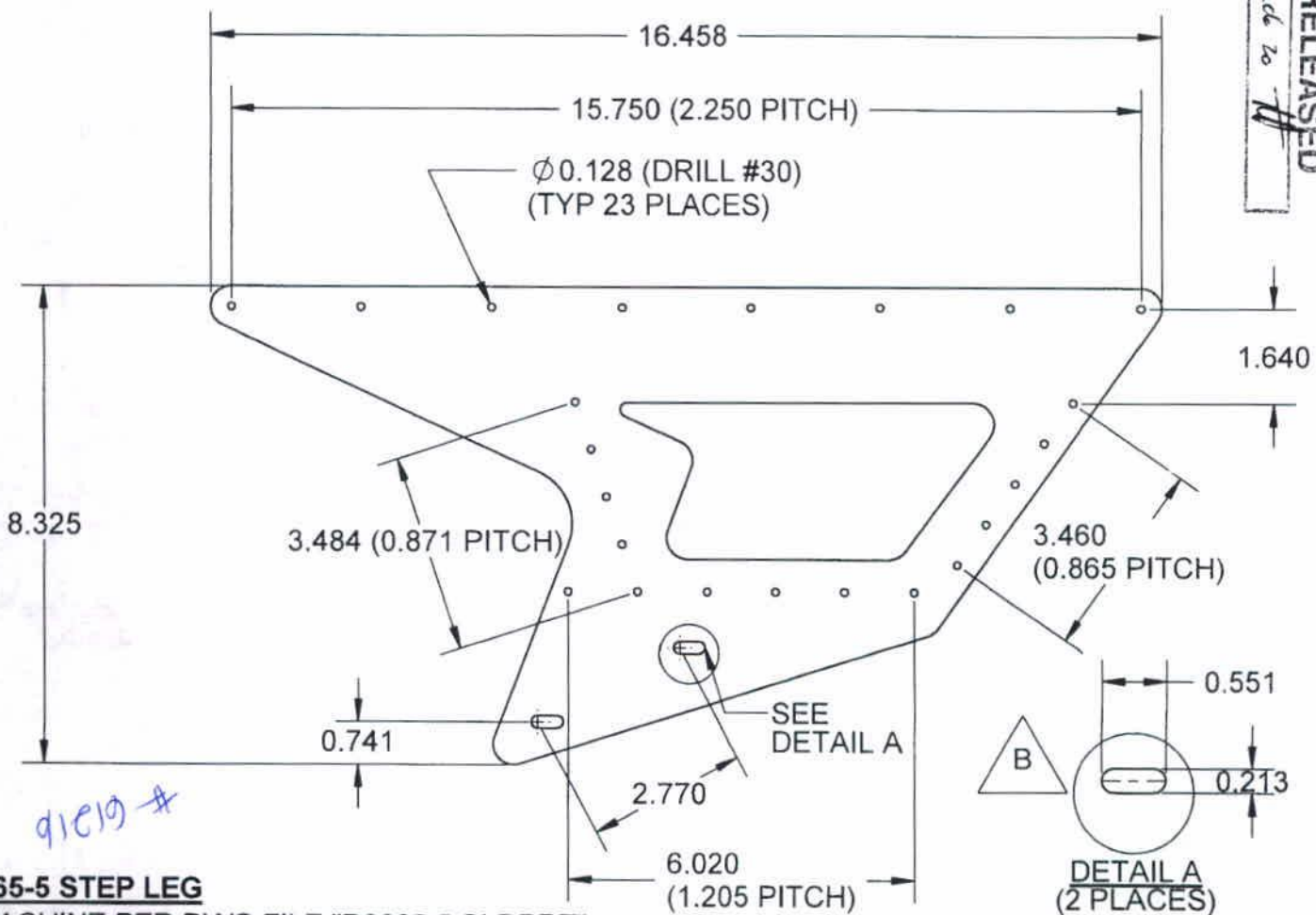
NOTE: Date & initial all entries

DART

DESIGN	<i>CP</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	DRAWING NO. D3065
DATE	06.05.23			REV. B
		TITLE	STEP LEG ASSEMBLY	SHEET 4 OF 5
				SCALE 1:3

RELEASED

06.06.20

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
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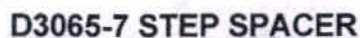
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RELEASED



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